

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027643**Date Inspected:** 23-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**Tower****In Process Visual Inspection**

This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3160. The joint being welded was Weld #W007 at Tower Shear Base Assembly designated as ED1-829.

During welding, ABF Quality Control (QC) John Pagliero was noted monitoring the welding parameters. Welding parameters were recorded as (A=246, V=23.2).

**Electroslag Weld Excavations**

This QA randomly observed ABF/JV welding personnel performing excavation of welds previously Ultrasonic Testing (UT) rejected. Quality Control (QC) Inspector John Pagliero performed Magnetic Particle (MT) and visual confirmation of excavations.

Excavations were recorded as follows:

Weld "H" – Y=7285mm, L=260mm, W=35mm, D=30mm

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Weld "H" – Y=4900mm, L=240mm, W=40mm, D=30mm

### Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of weld repair excavations on two locations on tower ESW "H". This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at these locations appeared to be in compliance with the contract specifications.

Excavations were recorded as follows:

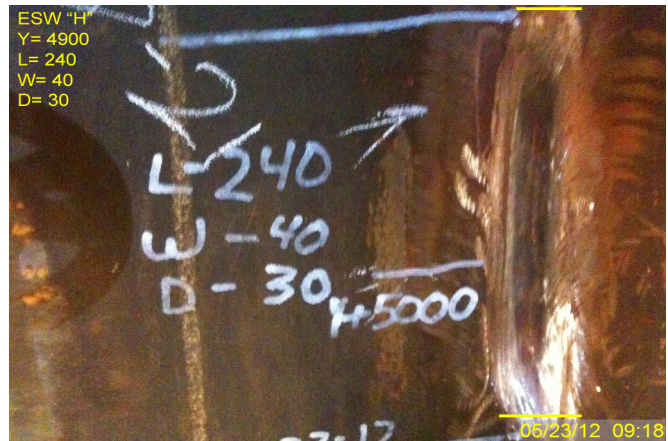
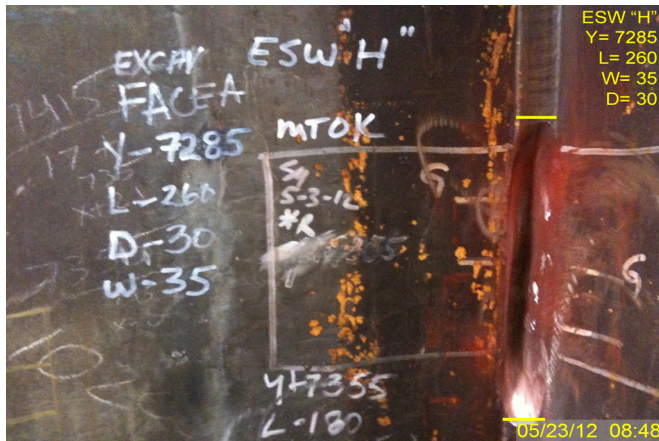
Weld "H" – Y=7285mm, L=260mm, W=35mm, D=30mm

Weld "H" – Y=4900mm, L=240mm, W=40mm, D=30mm

### Note:

This QA spent the duration of this shift reviewing and documenting the status and completion of various punch list items. This QA photo documented the current status of punch list items for further review. In addition, this QA collected supporting documentation such as QC Daily and Non Destructive Testing (NDT) reports to be submitted with punch list findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Clifford, William

Quality Assurance Inspector

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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**Reviewed By:**      Levell,Bill

QA Reviewer